

Date: Tuesday, 12/5/2006 8:15:48 AM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: LUG BRACKET
Job Number	: 29780B		
Estimate Number	: 10339		
P.O. Number	: N/A	Part Number	: D2658
This Issue	: 12/5/2006 S.O. No. : N/A	Drawing Number	: D2658 REV D
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : PURCHASED PARTS	Drawing Revision	: D
Previous Run	: 29228B	Material	: N/A
Written By	: <u>JA 06 12 05</u>	Due Date	: 1/5/2007
Checked & Approved By	: <u>JA 06 12 05</u>	Qty:	40 Um: Each
Comment	Est Rev:A New Issue 05-11-07 JLM Est Rev:B Now on Waterjet 06-08-23 JLM		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M1010S12GA	1010/1025/A21/6aA SHEET
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Comment: Qty.: 0.1197 sf(s)/Unit Total: 4.7880 sf(s)

1010/1025/A21/6aA SHEET

12 GAUGE .100" THK

Batch: M101094 ml 06 12 11 (40)

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET

1-Cut as per Dwg D2858

Dwg Rev: DProg Rev: D ml 06 12 11 (40)

2-Deburr if necessary

SAD 06:12:13 (39)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

SAD 06:12:13 (39)

5.0	BRAKE NC	NC BRAKE
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Comment: NC BRAKE

1-Deburr as required. SAD 06:12:13 (39)

2-Bend on CNC brake using DT8254 Identify as D2658

SAD 06:12:13 (39)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: PD Date: 06/12/11

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06/12/11	3.0	- 1 part Scrap - part moved <del>to</del> in water jet	<u>AS/04/2</u>	- destroy part	<u>PD</u> 06/12/11	<u>PD</u> 06/12/11	<u>AS/04/2</u>	<u>PD</u> 06/12/11

NOTE: Date & initial all entries

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Drawing Name: LUG BRACKET

Job Number: 29780B

Part Number: D2658

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

11/06/12/19

(39)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 258

C207102114

(39)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/02/19

(39)

Job Completion



C207102114

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

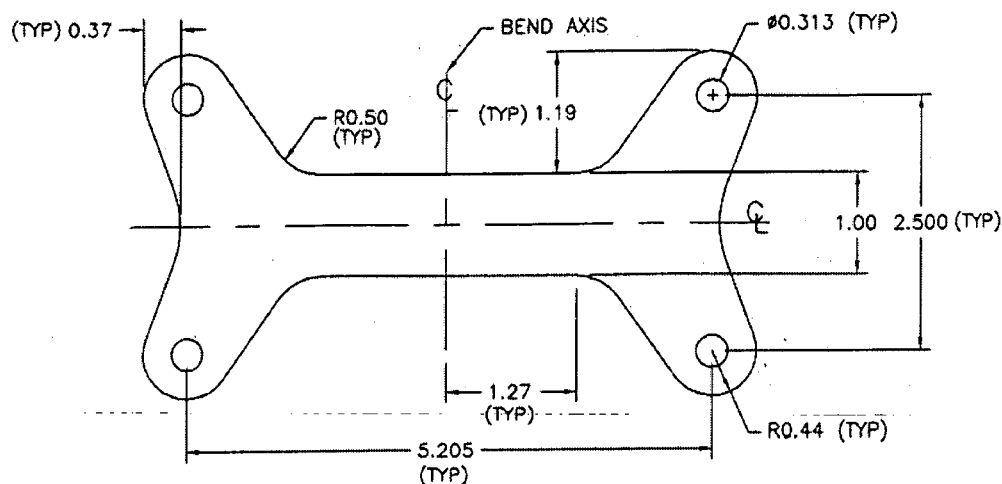
NOTE: Date & initial all entries



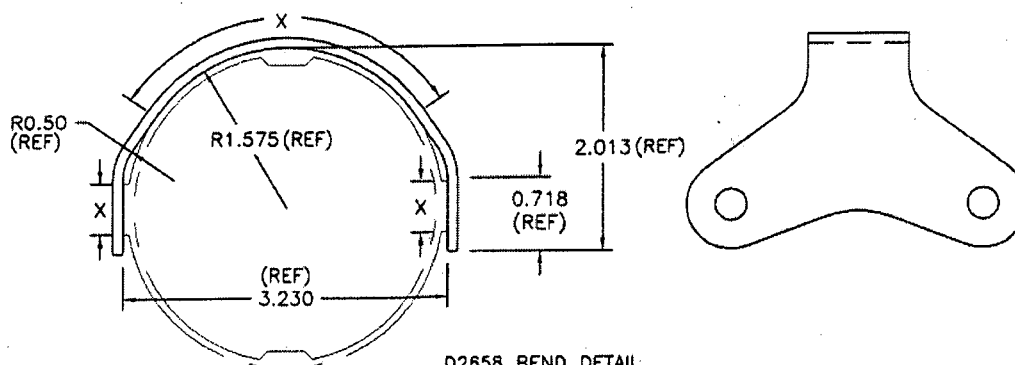


DESIGN #	DRAWN BY #	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED CP	APPROVED KE	DRAWING NO. D2658	REV. 0 SHEET 1 OF 1
DATE 98.12.14		TITLE LUG BRACKET	SCALE 5:9
A	97.11.03	NEW ISSUE	
B	97.12.18	5.205 WAS 5.015, ADD TOOLING HOLE	
C	98.10.23	UPDATE MATERIAL (TSR A1114)	
D	98.12.14	REMOVE TOOLING HOLE (TSR A1040)	

RELEASED  
98.12.14 DS



D2658- FLAT PATTERN  
SYMMETRICAL ABOUT BOTH CENTRE-LINES (C-C)



D2658 BEND DETAIL

D2658 SHOULD BE BENT SO THAT IT IS WITHIN 0.010 OF THE OUTSIDE PROFILE OF THE D2600-1 EXTRUSION IN THE AREAS INDICATED 'X' ABOVE.

GENERAL NOTES

MATERIAL: ASTM A36/A366/A569/A570 OR AISI 1010-1025 STEEL 0.100 THICK (12 GAUGE)  
MIN. ULTIMATE TENSILE STRENGTH = 42 ksi  
MIN. YIELD TENSILE STRENGTH = 28 ksi

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED  
ALL DIMENSIONS ARE IN INCHES

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 29780B